

Date: Thursday, 6/21/2007 1:51:48 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	CUPPED WASHER
Job Number	33096		
Estimate Number	12885		
P.O. Number	N/A	Part Number	D36283
This Issue	6/21/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	UNDER REVIEW D3628 REV A 07.06.08
First Issue	N/A	Project Number	N/A
Previous Run	33093	Drawing Revision	N/A
Written By		Material	N/A
Checked & Approved By		Due Date	6/28/2007
Comment	Est Rev:A New Issue 07-05-28 JLM	Qty:	50
		Um:	Each

POSITIVE RECALL

Additional Product	EFFECTIVE <u>07/06/21</u> AUTH <u>ML</u>
	RELEASED _____ DATE _____

Job Number:	
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Seq. #:	Machine Or Operation:	Description :
1.0	WATER JET	FLOW WATER JET 
		Comment: FLOW WATER JET cut per drwg D3628 Rev.A <i>ML 07 06 25</i>  (50)
2.0	M304S18GA	304/316 .050 Sheet 
		Comment: Qty.: 0.0300 sf(s)/Unit Total: 1.5000 sf(s) 304/316 .050 Sheet <i>ML 07 06 25</i>  (50)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>ML 07 06 25</i>  (50)
4.0	QC8	SECOND CHECK 
		Comment: SECOND CHECK <i>ML 07 06 26</i>  (50)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 <i>ML 07/06/27 x51</i>  (50)
		Comment: SMALL & MEDIUM FAB RESOURCE 1 FORM PER DRGW D3628 REV.A <i>ML 07/06/26</i>  (50)
6.0	QC5	INSPECT WORK TO CURRENT STEP 
		Comment: INSPECT WORK TO CURRENT STEP <i>En 07/06/28 x51</i>  (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUPPED WASHER

Job Number: 33096

Part Number: D36283

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

POWDER COATING

POWDER COATING



m 104846



(51)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

6/21/07/07-06-28

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



107/07/29 (51)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker on under side of part, then Stock
Location: 57120

RECALL
POSITIVE

107/07/29 (51)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(52)

Comment: FINAL INSPECTION/W/O RELEASE

107/06/29

Job Completion



POSITIVE RECALL

EFFECTIVE _____ AUTH _____
RELEASED _____ DATE 07/06/29

[Signature]

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

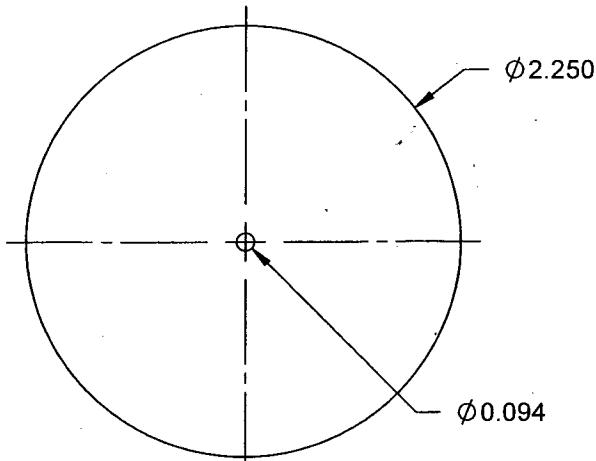
NOTE: Date & initial all entries

PRELIMINARY ISSUE

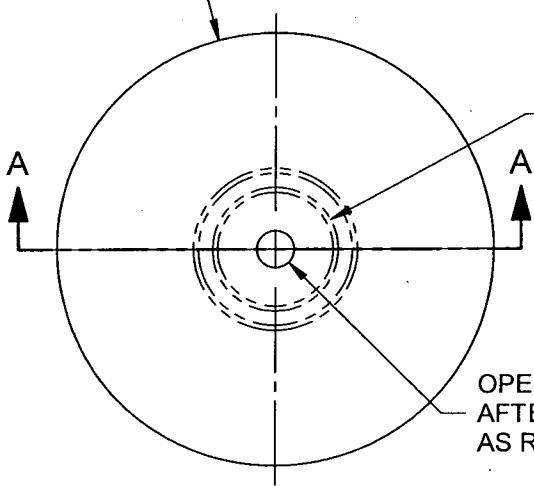
DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED	DRAWING NO. D3628	REV. A	SHEET 1 OF 1
DATE 07.06.08		TITLE CUPPED WASHER	SCALE 1:1	
REV A	DATE 07.06.08	DESCRIPTION NEW ISSUE		

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33096



$\phi 2.250$
(REF)



D3628-1F FLAT PATTERN

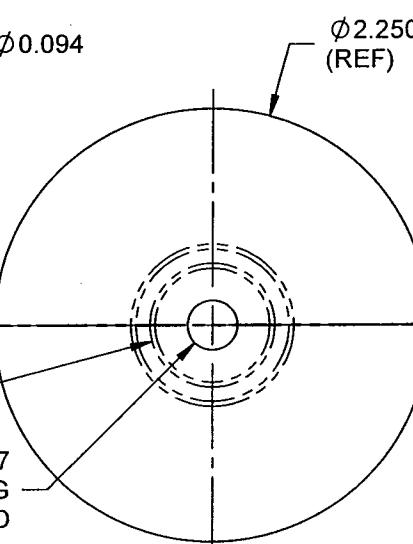
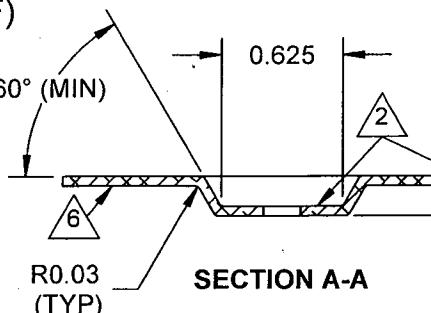
PUNCH $\phi 0.64 \times 0.16$ DEEP

OPEN TO $\phi 0.191$
AFTER PUNCHING
AS REQUIRED

PUNCH $\phi 0.64 \times 0.16$ DEEP

OPEN TO $\phi 0.257$
AFTER PUNCHING
AS REQUIRED

D3628-1 CUPPED WASHER
(MAKE FROM D3628-1F)



D3628-3 CUPPED WASHER
(MAKE FROM D3628-1F)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK) PER MIL-S-5019
(REF DART SPEC M304S18GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3 ONLY TOP SURFACE AS INDICATED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3628-1/-3" USING FINE POINT PERMANENT INK MARKER ON THE
UNDERSIDE OF THE PART AS INDICATED
- 7) WHEN DRILLING OUT THE CENTRE HOLE AFTER PUNCHING, ENSURE THAT THE HOLE IS DRILLED
CONCENTRIC TO THE CUPPED AREA, WITHIN 0.03

DART AEROSPACE LTD	Work Order:	33096
Description: Cupped P WASHER	Part Number:	D3608-3
Inspection Dwg: D3608 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>m/m</u>	Audited by: <u>/</u>	Prototype Approval: <u>✓</u>
Date: <u>07-06-25</u>	Date: <u>12-06-28</u>	Date: <u>07-06-26</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	